

Date: Tuesday, 7/11/2006 1:40:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY	
Job Number	: 27859B		Part Number	: D3324041	
Estimate Number	: 10852		Drawing Number	: D3324 UNDER REVIEW <i>Pt 1 06-07-11</i>	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 7/11/2006	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 7/11/2006	Type : LARGE FAB ASSY	Due Date	: 8/15/2006 Qty: 1 Um: Each	
Previous Run	: 27858B				
Written By	<i>See Comment Below</i>				
Checked & Approved By	<i>KA 06-07-11</i>				
Comment	: Est Rev:A 05.02.09 New issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33283	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch 2 D3328-3 Hinge Plate <i>B23727</i>	<i>Mo 06/08/02</i>
2.0	D33481	Clevis	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: Qty Part Number Description Batch 4 D3348-1 Clevis <i>B24713</i>	<i>Mo 06/08/02</i>
3.0	D33493	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch 2 D3349-3 Spacer Bushing <i>B23758</i>	<i>Mo 06/08/02</i>
4.0	D33671	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch 2 D3367-1 Mounting Bracket <i>B23862</i>	<i>Mo 06/08/02</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

D

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 27859B

Part Number: D3324041

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	M4130NTS0500W035	4130 Square tube .5 x .5

Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)

Material: 4130 Cond. N Square tube per MIL-T-6736,

1/2" x 0.035" wall

M4130N-TS0.500W.035) M17679

AA 06/08/02

6.0 M569EX05018F 569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)

Pick:

Qty Part Number Description Batch

28s, M569EX0.50-18F 1/2"-18gauge(.040") carbon steel M101738

AA 06/08/02

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3324

Qty Part Number Description Batch

3 D3324-1 Bottom Tube _____

4 D3324-3 Full Length Tube _____

2 D3324-5 Top End Tube _____

2 D3324-7 Bottom EndTube _____

10 D3324-9 Vertical Tube _____

M17679
Identify parts appropriately

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B

A/R/N/A Steel Rod 49430
4/30 Rod

4-Deburr as required

AA 06/08/02

8.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

PD 06-08-02 (1)

POSITIVE RECALL

EFFECTIVE 06-08-01 AUTH [Signature]

RELEASED 06-08-02 DATE [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-01	6	Waiting upon Mat'l Certs.					<i>06-08-01</i>

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: *DJ*Date: *06/08/04*

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 7/11/2006 1:40:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 27859B

Part Number: D3324041

Job Number:



Seq. #:	Machine Or Operation:	Description :
9.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	a.m 06-08-02 (1)
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 Jab08-03/1
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
11.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	N/B
12.0	DC	DOCUMENT CONTROL
		 D 06/08/04 (1)
	Comment: DOCUMENT CONTROL Inspection Level 21	

Job Completion



cLoc6/08/04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

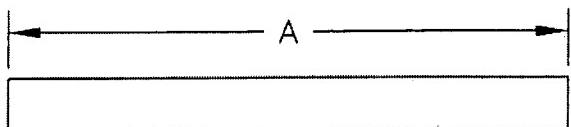
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

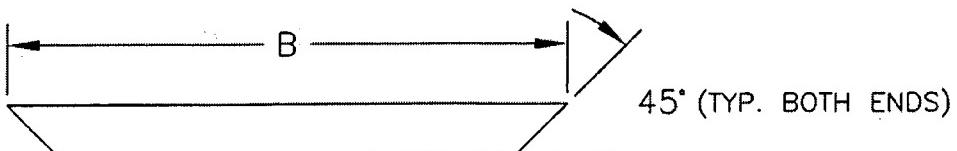
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
	A 04.10.20	NEW ISSUE	
	B 05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

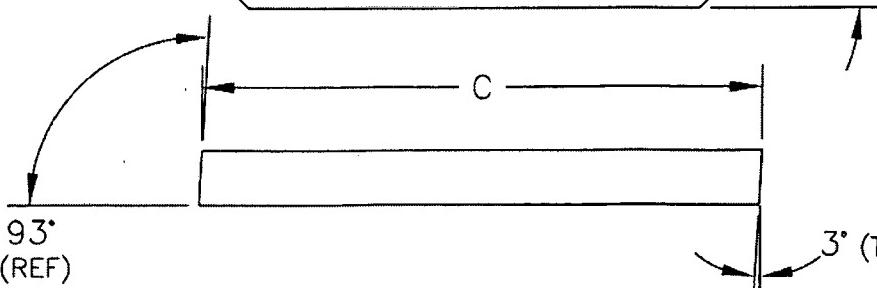
Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05 *PH*



45° (TYP. BOTH ENDS)



UNDER REVIEW

J.S. 07.05 PH
MISALIGNED
DIMENSION PLD

93° (REF) 3° (TYP. BOTH ENDS) SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO 27859 B

D3324-1/-3/-5/-7/-9

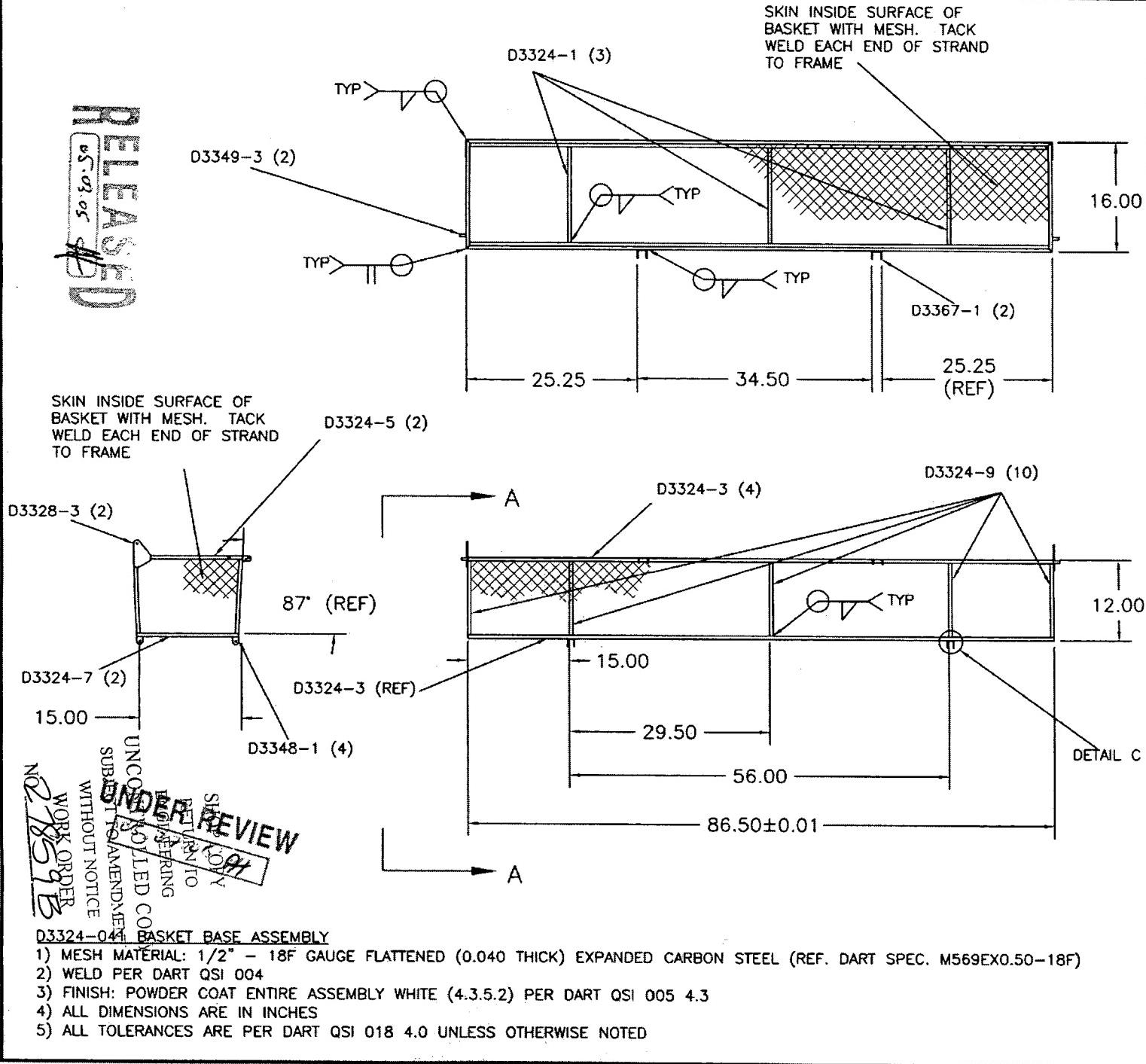
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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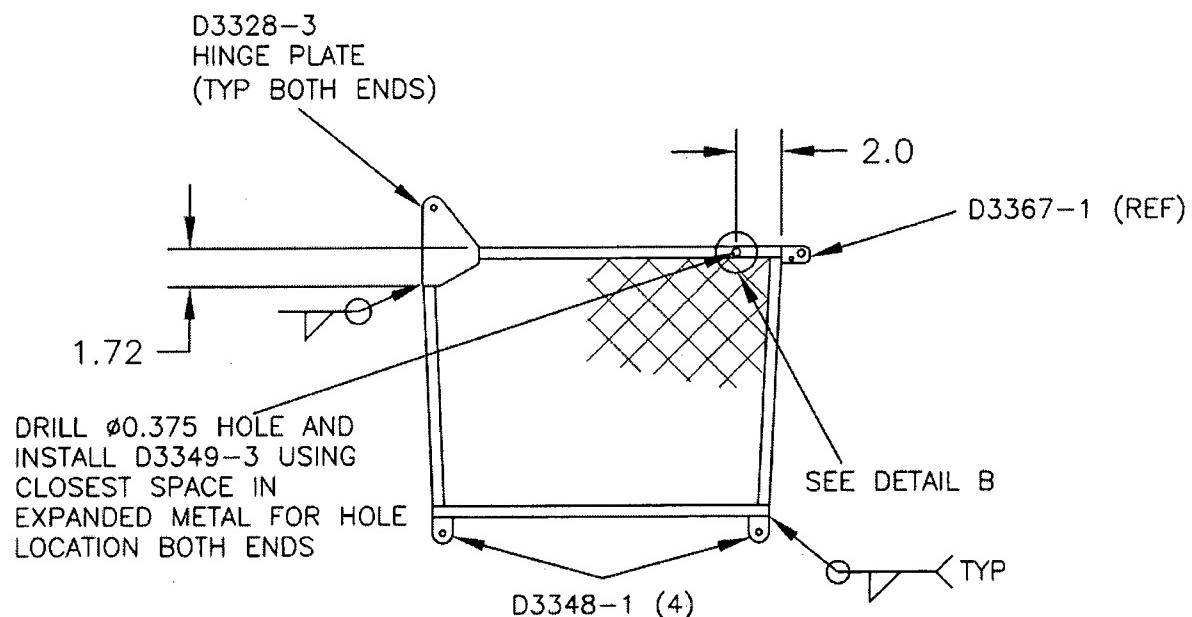
DART

DESIGN <i>MH</i>	DRAWN BY <i>MH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324
DATE 05.03.04	TITLE BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE 1:20

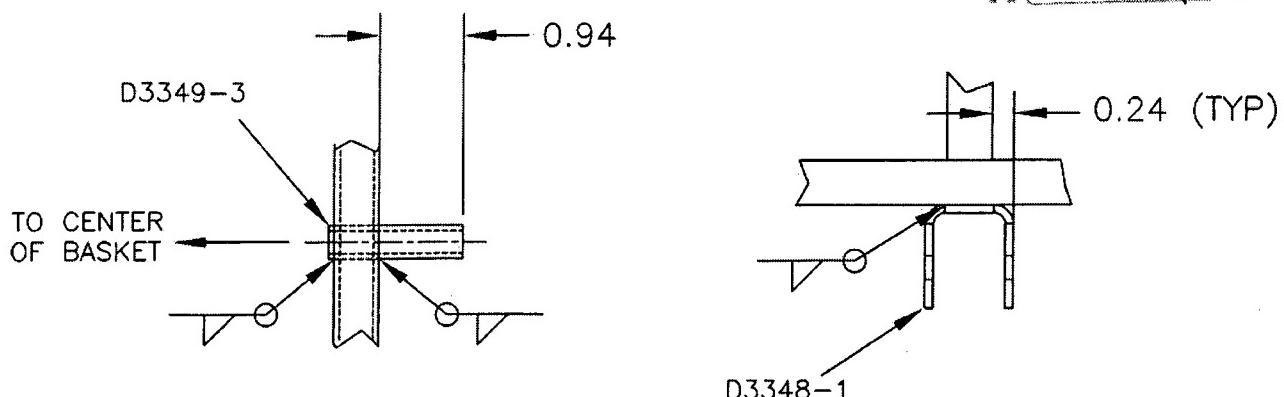


DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04	TITLE BASKET BASE ASSEMBLY	SCALE 1:8	



RELEASED
05.03.05



DETAIL B
(SCALE 1:2)

UNDER REVIEW
05.07.06 *PH*

SHOP COPY
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DETAIL C (SCALE 1:2)
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NO. *27859B*

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935, boulevard du Havre
Valleyfield (Québec)
J6S 5L1

TÉLÉPHONE : (450) 3
FAX : (450) 3

VENDU À / SOLD TO:

613-632-3336 613-632-4443

EXPÉDIEZ À / SH

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPACE
1270 ABERDEEN
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1725	JB	DAER
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NOMBRE QUANTITY	CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIÉ SHIPPED	DESC
			3X 2X12	ROD 4130 3/4" 2 X 12"
2	FMD1218F	2	12x4 1x20	EXPANDED METAL 2 X 4" X 6"
10				10x10

* Unités de mesure CLB Cént livres CPI Cent pieds UN Unité PI Pied PC Pied carré
 Units of measure CLB Hundred pounds CPI Hundred feet UN Unit PI Foot PC Square foot

CONDITIONS

ES MATERIAUX LIVRES ET FACTUREES TELS QUE DÉCRITS DÉMONTRENT LA PROPRIÉTÉ DE ACIER CAMP INC. JUSQUA PARFAIT PAIEMENT COMPLET
INCASSEABLE. LES RISQUES DE PERTES DU BIEN SONT À LA CHARGE DE L'ACHETEUR. LA GARANTIE DE QUALITÉ DU MATERIEL EST LA MÊME QU'ELLE DU FABRICANT. L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION, E
OUT COMPTE IMPAYÉ VERSER LES 30% D'OBIGATIONS ENTRAINANT DES FRAIS DE 2% PAR MOIS (24% PAR ANNÉE) QUI, SI ACCEPTÉ DE PAYER, LE
ENTRAÎNE L'UNE OU L'AUTRE DES 30 JOURS ENTRAINANT DES FRAIS DE 2% PAR MOIS (24% PAR ANNÉE) QUI, SI ACCEPTÉ DE PAYER, LE
VENDREUR NE PEUT ÊTRE FAIT RESPONSABLE. TOUTE RECLAMATION DOIT ÊTRE FAITE DANS LES 30 JOURS
APRÈS LA PRÉSENTATION DE CE DOCUMENT. TOUTE MARCHANDEIS ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REPRISE. ALORS
QUE UN RETOUR DE MARCHANDEIS NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. TOUTE MARCHANDEIS RETOURNÉE EST SUJETTE À DES FRAIS
SI MANIFESTATION DE 25%.

CONDITION

**ALL SOLD AND DELIVERED MATERIALS
ALL LOST MATERIALS ARE AT THE BUYER'S
RISK. THE BUYER HEREBY AGREES TO PAY THE
BUYER HEREBY AGREES TO RESPECT THE
DELIVERY CHARGES OF 2% PER MONTH. C
CONTRACT WILL LEAD TO PAYMENT BY
SESSION OF THE GOODS SOLD. * AN
ITEM HAS BEEN DAMAGED, CUT-OUT OR MODI
FIED TO A 25% RESTOCKING CHARGE**

MARCHANDISE RECHIE EN

PRÉPARÉ / PREPARED **VÉRIFIÉ / VERIFIED**

VÉRIFIÉ / VERIFIED

LIVRE / DE LIVRE **HEURE / TIME**

✓ 152.00

2

SIGNATURE DU CLIE

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Initial

100

Receiving Report